

Work Order ID 57333

April 5, 2010 2:37:56 PM



Page 1

Item ID: D2905

Accept



Setup Start



Revision ID:

Item Name: Web, 315 Skidtube

Stop



Start Date: 05/04/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 09/04/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

PC

Date: 10-4-05

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2905

Rev A1

100

0.00



Skidtubes

Memo

0.00

Skidtubes

LANDING GEAR RESOURCE 1

1-Cut D2600-5 Extrusion to length as per-Dwg D2905

2-Deburr ends

3- Drill pilot holes in web as per Dwg D2905 using drill jig DT8430

4- Open holes to finish size as per Dwg D2905

5- Deburr

11/2/14/19

10-5-5

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

10 0 BER 10/5/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57333

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Page 2

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Required Date: 09/04/2010 Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				10	11/05/15		
130 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				10	10-5-6		
140 Packaging Packaging	Identify as per dwg & Stock Location: <u>LL</u> Memo	0.00 0.00				10	11/05/16		

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NOTE: Date & initial all entries

Work Order ID 57333

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Item ID: D2905

Revision ID:

Item Name: Web, 315 Skidtube

Start Date: 05/04/2010 Start Qty: 10.00

Required Date: 09/04/2010 Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/05/06 *JS*

MA

10-5-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 5, 2010 2:38:01 PM

Page 1

Work Order ID: 57333

Parent Item: D2905

Parent Item Name: Web, 315 Skidtube

Comments: IPP A□00.01.11□New Issue□EC□
cause:repair web drilling Jig. JLM

Start Date: 05/04/2010

Required Date: 09/04/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2600-5-108		Manufactured	No				Each	228.0000	10.0000			
Extrusion 'I Beam' thin												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

38589

47814

228

10

218

④

11/04/19

⑥

11/04/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: B 57333
Description: Web Jig		Part Number: 02905
Inspection Dwg: 02905 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00	0.030	2.00				
5.92	0.030	5.92				
10.25	0.030	10.25				
14.17	0.030	14.17				
22.47	0.030	22.47				
26.93	0.030	26.93				
31.69	0.030	31.69				
41.67	0.030	41.67				
46.13	0.030	46.13				
50.59	0.030	50.59				
55.05	0.030	55.05				
59.51	0.030	59.51				
63.97	0.030	63.97				
68.43	0.030	68.43				
72.89	0.030	72.89				
77.35	0.030	77.35				
82.60	0.030	82.60				
95.89	0.030	95.89				
100.17	0.030	100.17				
104.44	0.030	104.44				
106.44	0.030	106.44				

Measured by: M	Audited by: BE	Prototype Approval:	N/A
Date: 12/4/29	Date: 10/04/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	BS 7333
Description: web 5.9		Part Number:	02905
Inspection Dwg: 2905 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

Measured by:	KL	Audited by:	BE	Prototype Approval:	N/A
Date:	10/4/29	Date:	10/04/29	Date:	N/A

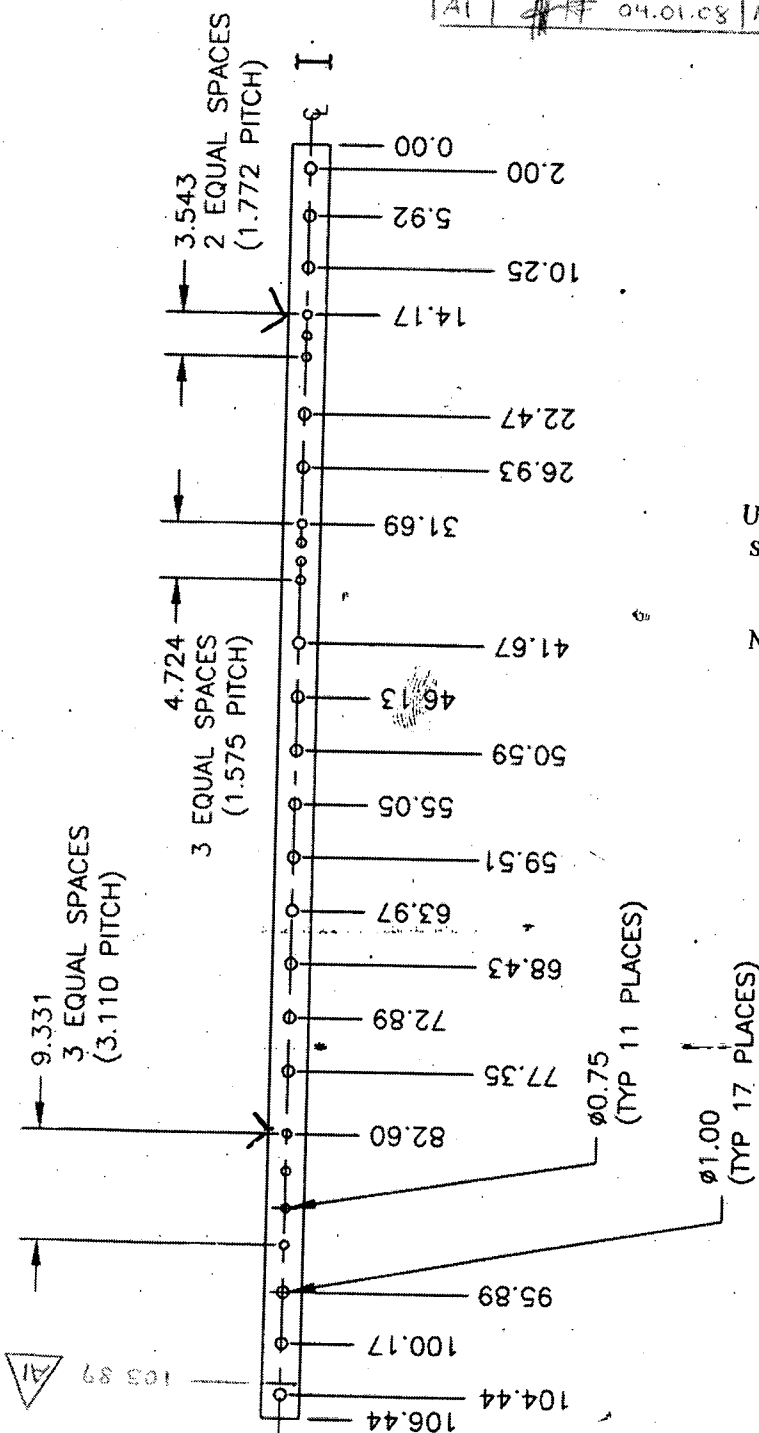
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART



DESIGN <i>SCP</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>CP</i>	APPROVED <i>RF</i>	DRAWING NO. D2905	REV. A SHEET 1 OF 1
DATE 99.09.14	TITLE WEB	SCALE 1:15	
A	99.09.14	NEW ISSUE	
A1	04.01.08	NEW LENGTH 103.89 WAS 106.44	

RELEASED
99.09.28 DS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *57333*
DS10-4-05

NOTES:
MAKE FROM D2600-5 EXTRUSION
ALL HOLES ON CENTERLINE
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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